Page 1

Tuesaay, June 0	8, 2010 11:3	1:44 AM 									!		
Revision ID:	D105-674-01			١.	Accept				ll s	-			
Item Name:	Skidtube, Grey	У -					1				Stop		
Start Date: Required Date:	6/8/2010 6/17/2010	Start Q	•			Cust Iter Custome	•		;				·
Reference:		-	•	1100101		Custome	.1 •						
Approvals:	Process Pla	n:	R	Date: <u>///-/</u>	~OS Tooling:		Date:	-	.		Start		
	QC:			Date:	SPC (Y/N):		Date:		! !		Stop		
Sequence ID/ Work Center II)	Operation Descript			Set Up/ Run Hours	Tool II	Tool#	Plan Code	Accept Qty	Reje Qty		eject umber	Insp. Stamp
Draw Nbr	Rev	ision Nbr					,		+			-	
D2966	Rev	A2									i i		
		DOCUME	NT CONTR	OL	0.00		·					4-	7
DC Document Control	•		Memo Photocopy	bluefile & type lab	0.00 els per PPP D105-674-011C	G CHG002	106/30						•
							!		1 · · · · · · · · · · · · · · · · · · ·				
		Skidtubes			0.00			_					
Skidtubes Skidtubes			Memo 1-Determir 2-Drill #30 holes.	ne square end of tube pilot holes using DI	0.00 and deburr 8678. Open holes to Ø5/16"	(0.313"). Deburr) /	0	- (, 9 -	10
120		BENDING	MACHINE	- SKIDTUBES	0.00				•				:
CNC Bend 1 CNC Delta 100 Bend	der		Memo Bend tube	as per program BO10	0.00 O5 on CNC Bender and Dwg [02966 as per folio 1		F	>	/(<u> </u>	-6	- <i>J</i> C

Dart Ae	rospace Li	td						:	L
W/O:	·		WC	RK ORDER CHANGE	S	7			•
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approv QC Inspec
L									
Part No):	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA]	Date: _	
	Resc	olution:	Disposition	n:	QA: N/C Cld	osed:		Date: _	
NCR:	*		WORK ORDE	R NON-CONFORMAL	NCE (NCR)			
DATE	STEP	Description of NC	 	Corrective Action Section		Verifica	tion	Approval	Approva
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sectio		Chief Eng	QC Inspec
		٠.							
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Work Order ID 59585



Page 2

Tuesday, June 0	3, 2010 11:3	1:44 AM											
Item ID: Revision ID:	D105-674-01	11 G		Accept				\$	Setup	Start			
Item Name:	Skidtube, Gre	y								Stop			
Start Date: Required Date: Reference:	6/8/2010 6/17/2010	Start Qty: 1 Req'd Qty: 1		1101 t 101	Cust Ite						118811181 81	III III	
Approvals:	Process Pla	n:	Date:	Tooling:		Date:		1	Run	Start			
	QC:		Date:	SPC (Y/N):		Date:	· · · · · · · · · · · · · · · · · · ·			Stop			
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool II		Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	
Skidtubes		Skidtubes Mem	10	0.00						!		: :	
Skidtubes		2-Cu 3-Del 4-Dri 5-Loc on Fv 6-Cla 7-Op 8-Op D296 9-Del	wd end of tube and drill #4 imp DT8679 to the tube. I en Aft Cap holes using #6 en wearplate holes and two	DT8185D 3678 os in Aft Cap holes. Ensure DT 0 Fwd bushing. Orill all #30 wearplate and cross drill o side holes to Ø19/64" (0.297")	bolt holes.		>		10)(6-	· 10)
140 		Skidtubes		0.00		·					-		
Skidtubes		Mem	ın	0.00			,			<u> </u>	· · · · · · · · ·		
Skidtubes				2966 and QSI 004. Fill #40 Fw	d cleco hole. A	m 11424	/Q	Be	E POJ	66/14	/ .		

W/O:			WO	RK ORDER CHAI	NGES					
DATE	STEP	PRO	OCEDURE CHAN			By Date			Approval Chief Eng / Prod Mgr	Approv QC Inspec
Part No		PAR #:								
NCR:				R NON-CONFOR						
		Description of NC		Corrective Action	Section B		Verifica	tion	Approval	Anna
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date	Section		Chief Eng	Approva QC Inspect

Work Order ID 59585



Page 3

Insp.

Tuesday, June 08, 2010 11:31:44 AM Item ID: D105-674-011G Accept Setup Start **Revision ID:** Stop **Item Name:** Skidtube, Grey **Start Date:** 6/8/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/17/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: _____ Date: ____ Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 150 QC10- Inspect visual per QSI004- ground welds 0.00 0.00 Memo Quality Control 160 QC5- Inspect part completeness to step on W/O 0.00 0.00 Memo Quality Control 170 0.00

0.00

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

10-6-15

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** DATE **STEP Approval PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA ____ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Initial Sign & **Action Description** Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

Work Order ID 59585

Tuesday, June 08, 2010 11:31:44 AM



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Item	ID:
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D105-674-011G

Accept

Setup Start



Revision ID:

Item Name:

Skidtube, Grey

Start Date: 6/8/2010 Required Date: 6/17/2010

Start Qty: 1.00

Req'd Qty: 1.00

Date: _____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

180



Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Memo

Run Hours

SPC (Y/N):

Set Up/

0.00

0.00

Tool # Plan Code

Accept Qty

١,

Reject Reject Qty

Insp. Number Stamp

190

Skidtubes

Skidtubes

Skidtubes

0.00

0.00

1-Open crossbolt holes to finish size as per Dwg D2966

2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes &

3-Deburr holes inside & outside, blow out chips

remove alodine to prepare for welding as per Dwg D2966

M10/6/15

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** DATE **STEP Approval PROCEDURE CHANGE** Bv Qtv Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: ___ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval** Approval Sign & Initial **Action Description** Section A Section C Chief Ena QC Inspector Chief Eng Chief Eng Date

Work Order ID 59585 Tuesday June 08, 2010, 11:31:44 AM



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Tuesaay, June							#1 11 2 11 22 111	**********		-		
Item ID:	D105-674-0	11G		Accept					Setup S	Start		
Revision ID: Item Name:	Skidtube, Gre									Stop		
Start Date: Required Date	6/8/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Iter Custome					i I I I I		0 !
Reference:		neq a Qiy. 1.00			Custome	1.						
· · · · · · · · · · · · · · · · · · ·						 	_]	Run	Start		
Approvals:	Process Pla	an:	Date:	Tooling:		Date:		i		Stop	(
	QC:		Date:	SPC (Y/N):		Date:						
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool II	Tool#	Plan Code	Accept Qty	Rejec Qty	1	Reject Number	Insp. Stamp
200		Skidtubes		0.00		I'm magan						
Skidtubes Skidtubes		Memo		0.00		• .	-	. 1		1		
Sandados	1	Pick:	o in place per QSI 015. (En: umbe □Description□Batch aflex-291□ \$#\$ \$ □ piry date :□ 11 2010	start time and time	e 11:45	An 10.	-06-17 0-04	7 MB e-18 1	mb			
	v.	weld one sid Pick:	ssbolt Spacers as per Dwg E de, pass 5/8" drill; weld othe umber □Description□Batcl minum Rod□	r side, pass 5/8" drill.	1 1							
			30" drill to remove spillove pillover for D2971 crossbolt									*
		4-Grind wel	ds flush as per Dwg D2966	Nw		06 A	,	ı				
210		QC10- Inspect visual per	r QSI004- ground welds	0.00	10-	000	.)					
QC		Мето		0.00		•		!	- -:			
Quality Control				(0/0)	6/21							

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval **Approval DATE** STEP **PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: ____ NCR: Yes No DQA ____ Date: _____ Resolution: _____ QA: N/C Closed: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **STEP** DATE **Approval Approval** Initial **Action Description** Sign & Section A Section C QC Inspector Chief Eng Chief Eng Chief Eng Date

Work Order ID 59585

Tuesday, June 08, 2010 11:31:44 AM



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Item ID:

D105-674-011G

Accept

Setup Start

Stop

Start



Revision ID:

Item Name:

Skidtube, Grey

Start Date:

6/8/2010

QC:

Start Qty: 1.00

Required Date: 6/17/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

0.00

SPC (Y/N):

Set Up/

Date: Date:

Tool # Plan

Code

Run Stop

Reject

Qty

Insp.

Stamp

Sequence ID/

Work Center ID

220

QC

Quality Control

Operation **Description**

QC5- Inspect part completeness to step on W/O

0.00

Run Hours

Accept

Qty

Reject

Number

230

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

M112588

0.00

FINISH TIME:

0.00

240

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00 0.00

Dart Aerospace	Ltd
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w/o:59	585	WORK ORDER CH	ANGES			•	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
iolobles	221	Realodine as per PAR-09-043	H	10106125	l	10.03.06	NOARY

Part No: 105-674-016 PAR #:	Fault Category:	NCR: Yes No DQA	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMANCE	(NCR)			
DATE	0750	Description of NC		Corrective Action Section B		Varification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
						·		j
·								
				.				

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Insp.

Tuesday, June 08, 2010 11:31:44 AM Item ID: D105-674-011G Accept Setup Start **Revision ID:** Stop Item Name: Skidtube, Grey **Start Date:** 6/8/2010 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/17/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: Tooling: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 250 0.00 HandFinishing =) M 10/06/29 HandFinish 0.00 Memo Hand Finishing 1-Inspect for foreign objects as per QSI 024 2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side. Qty□Part Number□Description□Batch A/R | | Sikaflex-291 | /11-1093 Sikaflex expiry date: ☐ / O (/ 3-Wing Walk as per Dwg D2966 and QSI 005 4.4 \(\text{Batch:} \) \(\text{M(14)} \) \(\text{Z} \) 260 QC3- Inspect Part Finish

QC

Quality Control

10/06/29

Memo

0.00

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval **Approval** DATE STEP PROCEDURE CHANGE Date Bv Qtv Chief Eng / Prod Mgr QC Inspector Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA ____ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: Date: **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval Action Description** Sign & Initial Section A Chief Eng Section C QC Inspector Chief Eng Chief Eng Date

Work Order ID 59585	Wo	rk	Or	der	ID	5958	15
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Tuesday, June 08, 2010 11:31:44 AM



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Item ID: D105-674-011G **Revision ID:** Item Name: Skidtube, Grey **Start Date:** 6/8/2010 Start Qty: 1.00 Required Date: 6/17/2010 Req'd Qty: 1.00



Setup Start

Stop



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Accept

Date:

Date:_

Start



Stop

Sequence ID/ Work Center ID

270

QC:

Operation **Description**

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Run

Reject Number

Insp. Stamp

Quality Control

QC

Memo

0.00

Date:

******ENSURE INSERT ARE AT LOCATION (6) AS PER DWG

D2966*****

280

Packaging Packaging

Pick Kit

0.00

Memo

0.00

10-6.

290

Quality Control

QC4- 100% Inspect kits for completeness

Memo

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval **Approval** DATE STEP **PROCEDURE CHANGE** By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ___ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval Approval** Initial **Action Description** Sign & Section A Section C Chief Eng QC Inspector Chief Eng Date Chief Eng

Work Order ID 59585

Tuesday, June 08, 2010 11:31:44 AM



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Item ID:

D105-674-011G

Accept

Setup | Start

Stop



Item Name: **Start Date:**

Revision ID:

Skidtube, Grey

6/8/2010 Start Qty: 1.00 Required Date: 6/17/2010

Req'd Qty: 1.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

Date:

Run Start

Qty

Date:_

SPC (Y/N):

Date:

Tool # Plan

Code

Accept

Qty

Reject Reject

Stop

Insp. Stamp

Work Center ID 300

Sequence ID/

Packaging

Packaging

Operation Description

Packaging

Set Up/ **Run Hours**

Identify and pack for shipping as per PPP D105-674-011G

0.00

0.00

Number

310

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Location:

Memo

0.00

0.00

U 10.07.0

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval DATE Approval STEP PROCEDURE CHANGE Bv Date Dtv Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ QA: N/C Closed: ____ Date: ____ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC STEP** Verification DATE **Approval Approval** Initial Sign & **Action Description** Section A Section C Chief Ena QC Inspector Chief Eng Chief Eng Date

Picklist Print Tuesday, June 08, 2010 11:31:49 AM Work Order ID: 59585 Parent Item: D105-674-011G Parent Item Name: Skidtube, Grev **Start Date:** 6/8/2010 Required Date: 6/17/2010 **Comments:** IPP Rev:A□04.07.07□New Issue□KJ/JLM Start Qty: 1.00 Required Qty: 1.00 Component Item ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Qty per Kit Total Item Name Qty Date Item ID Purch Item Location Location Seq ID Measure Hand Issued Qty Issued D2962-125 Manufactured No 110 Each 30.0000 Outer Tube Extrusion Location Loc Oty Loc Code HALL 30 D2964 Manufactured Each 23.0000 Cap Location Loc Qty Loc Code LG BE 10/06/14 P3 NB10-06/14 23 14101 23 D2976 Manufactured 200 Each 0.0000 BO 105 Skidtube I Beam D2971 Manufactured No 200 Each 31.0000 Cross Bolt Spacer Location Loc Qty Loc Code LG 31

44445 31 D2973 Manufactured No 200 Each 180.0000 Cross Bolt Spacer Location Loc Oty Loc Code LG 180 14636 180

BE 19/06/21

Page 1

Status

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Approval DATE **STEP PROCEDURE CHANGE** Bv **b**tv Date Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: ____ QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification DATE **STEP Approval** Approval **Action Description** Sign & Initial Section A Section C QC Inspector Chief Ena Chief Eng Chief Eng Date

Tuesday, June 08, 2010 11:31:49 AM

Work Order ID: 59585

Parent Item:

D105-674-011G

Parent Item Name: Skidtube, Grey



Start Date: 6/8/2010

Required Date: 6/17/2010

Comments: IF	PP Rev:A□04.07.0	07□New Issue□K.	I/JLM					S	Start Qty: 1.00		Require	ed Qty: 1.0	00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2965	*	Manufactured	No			250	Each	49.0000		1		· · · · · ·	
				<u>Location</u> FP4	52057	<u>Loc</u>	_	<u>Loc Code</u> 36016	· · ·	X) >	M 10!	106/2	9
D2970-1 		Manufactured	No			250	Each	23.0000	1	1			
				<u>Location</u> FP	43726	Loc	Oty 23 7 16	Loc Code		KIY	1 101	06/2	9
D2970-3 		Manufactured	No		10210	250	Each	16.0000		1			
				<u>Location</u> FP	48214	Loc	Oty 16 16	Loc Code	_	x T H	102	oelz	Ĺ
D3176-1 		Manufactured	No			250	Each	15.0000	1.	1			
				Location ST041	37586	<u>Loc</u>	15 15	Loc Code	-	XI JU))) / (h (] -	,
							;	-	. –	p	1000	66 L	Ce

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval DATE Approval **STEP** PROCEDURE CHANGE Bv Qtv Date Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: _____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** DATE Verification **STEP Approval Approval** Initial **Action Description** Sign & Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

Picklist Print Tuesday, June 08, 201	0 11:31:49 AM	,							ı			Page 3
Work Order ID: 5958												
Parent Item Name:	5-674-011G Skidtube, Grey						# 9 4	Si	art Date: 6/8/2	2010	Required	Date: 6/17/2010
Comments: I	PP Rev:A□04.07.0	07□New Issue□K.	J/JLM		_		1	S	Start Qty: 1.00		Require	d Qty: 1.00
Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
03176-3 		Manufactured	No			250	Each	23.0000		1		
				<u>Locatio</u> ST041	<u>n</u>	Loc	Oty 23	Loc Code	 :			
				51011	37585 (4896)		3 20			x1 刈	lolo	6129
ALS7-1032-130		Purchased	No			250	Each	17.0000	36	36		
iscit				<u>Locatio</u> ST282	<u>n</u>	Loc	Oty	Loc Code		x 3/.	нλ	10106/29
ЛS27039-1-08		Purchased	No	31282	113238	250	17 , / 17 ; Each	41472 1,481.000		26		10,0,0,0
			110			230	Lacii	1,461.000				
				<u>Locatio</u> ST291	<u>n</u>	Loc	Oty 1481	Loc Code	!			
				51271	110552		44		; <u> </u>	y 2. G	ul u	oloulza
AN960JD10L	NAS1149D0332J	Purchased	No		114718	250	200 Each	3,795.000		28		
Washer										··		
				<u>Locatio</u> ST348	<u>n</u>	Loc	3795	Loc Code				
					10985		3795		-	828	JY 10	106129
Tuesday, June 08, 201	0 11:31:49 AM		:		Shop Pa	cket Print			1			Page
Tuesday, June 08, 201	0 11:31:49 AM				Shop Pa	cket Print	1					Pag

Dart Ae	rospace L	td							
W/O:			WC	ORK ORDER CHANGE	S				39
DATE	STEP	PR	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
		·							
Part No				gory:					
	Reso			n:				Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAN	ICE (NCR)			
DATE	CTED	Description of NC	·	Corrective Action Section		Verifica	ion	Approval	Ammraya
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approva QC Inspect
					}			:	
									?

Picklist Print Page 4 Tuesday, June 08, 2010 11:31:49 AM Work Order ID: 59585 Parent Item: D105-674-011G Parent Item Name: Skidtube, Grey **Start Date:** 6/8/2010 Required Date: 6/17/2010 Comments: IPP Rev:A□04.07.07□New Issue□KJ/JLM Start Oty: 1.00 Required Qty: 1.00 Component Item ID/ Replacement Mfg/ Primary Bin Last Route Unit of Qty per Kit Total Qty on Otv Date Status Item Name Item ID Item Location Purch Location Seq ID Measure Hand Issued Issued Qty MS27039-1-09 No Purchased 250 Each 455.0000 Screw Location Loc Qty Loc Code ST291 455 111650 420 10/06/24 18057 35 D2972 Manufactured 290 Each 111.0000 Bushing Location Loc Oty Loc Code ST032 111 33544 80 44160 31 D2974 Manufactured No 290 Each 7.0000 Packer Location Loc Qty Loc Code ST032 42715 7 Manufactured 290 Each 11.0000 10.6.34 Wearshoe Location Loc Oty Loc Code ST497A 11 41443 10 Tuesday, June 08, 2010 11:31:49 AM **Shop Packet Print** Page 4

Dart Ae	rospace	Ltd							•
W/O:			W	ORK ORDER CHANGE	S			¥	•
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA		Date:	
		solution:							
NCR:				ER NON-CONFORMAN					
DATE	CTED	Description of NC		Corrective Action Section	В	Verifica	tion	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Approval Chief Eng	Approva QC Inspect
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									7 () () () () () () () () () (

Picklist Print Tuesday, June 08, 2010 11:31:49 AM Page 5 Work Order ID: 59585 Parent Item: D105-674-011G ARK 1981 ARKA BIN 1986 BIN 1981 BIN ARKA 1984 ARKA 1984 ARKA Parent Item Name: Skidtube, Grey Start Date: 6/8/2010 Required Date: 6/17/2010 Comments: IPP Rev:A□04.07.07□New Issue□KJ/JLM Start Qty: 1.00 Required Qty: 1.00 Component Item ID/ Replacement Mfg/ Primary Bin Last Route Item Name Unit of Qty on Qty per Kit Total Qty Item ID Purch Date Item Location Location Status Seq ID Measure Hand **Qty** Issued Issued AN4-51A Purchased No 290 Each 24.0000 3 MILYGYI Bolt Location Loc Qty Loc Code ST361 24 112720 2 113121 1 114495 21 AN960JD10L NAS1149D0332J Purchased No 290 Each 3,795.000 Washer Location Loc Oty Loc Code ST348 3795 110985 3795 MS21042L4 Purchased No 290 Each 3,972.000 Nut Location Loc Oty Loc Code ST139 2 111827 2 ST300 3970 113422 68 114523 894 114718 1000 114784 2000 9063

W/O:			WO	RK ORDER CH	IANGES				₩	
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Part No: PAR #: _										<u></u>
<u>-</u>	Resolution:								Date: 	
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DATE	STEP	Description of NC		Corrective Action	Vi Ciam 9		Verificat	ion	Approval	Approva
		Section A	Initial Chief Eng	Action Descrip Chief Eng	ption 	Sign & Date	Section	C	Chief Eng	QC Inspect
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Picklist Print

Tuesday, June 08, 2010 11:31:49 AM

Page 6

Work Order ID: 59585

Parent Item:

D105-674-011G

Parent Item Name:

Skidtube, Grey

Comments:

IPP Rev:A□04.07.07□New Issue□KJ/JLM





Start Date: 6/8/2010

Required Date: 6/17/2010

Start Qty: 1.00

Required Oty: 1.00

Component Item ID/	Domlosson	7.0									require	u Qıy. 1.0	<i>7</i> 0
Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Otv	Qty Issued	Date Issued	Status
MS27039-1-08	 	Purchased	No			290	Each	1,481.000	26	8	+		

Screw

Location	Loc Oty	Loc Code
ST291	1481	
110552	44	
110835	1237	
114718	200	

10-6-30 8

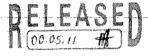
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DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Cty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date: _	
	Res	olution:	Disposition	1:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMAI	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section	Section B			Approval	
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date			Chief Eng	Approval QC Inspecto
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DESIGN RF	DRAWN BY	DART	AEROSPA BELLEV	ACE /UE, WA	USA,	INC.
CHECKED	APPROYED	D2966			SH	REV. A
DATE		TITLE		············		SCALE
00.03.08		BO 105 S	SKIDTUBE AS	SSEMB	LY	NTS
Α	00.03.08	NEW ISS	UE			



Qty	Part Number	Description
Χ	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
11	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE III
1	D2971	CROSS BOLT SPACER S
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130	INSERT
	or ALS4-1032-130	
	or AKS7-1032-130	
	or AKS4-1032-130	
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
· 1	D3176-1	Bushing-
1	D3176-3	MUT

SHOP CUPY RETURN TO ENGINEERING CONTROLLED COPY IBJECT TO AMENUMENT WITHOUT NOTICE

WORK ORDER 5 NO 5 45 85 BS 10-6-08

GENERAL NOTES:

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/ -291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART **QSI 005 4.4 (OPTIONAL)** BLACK SANDTEX (REF 43.5.7)

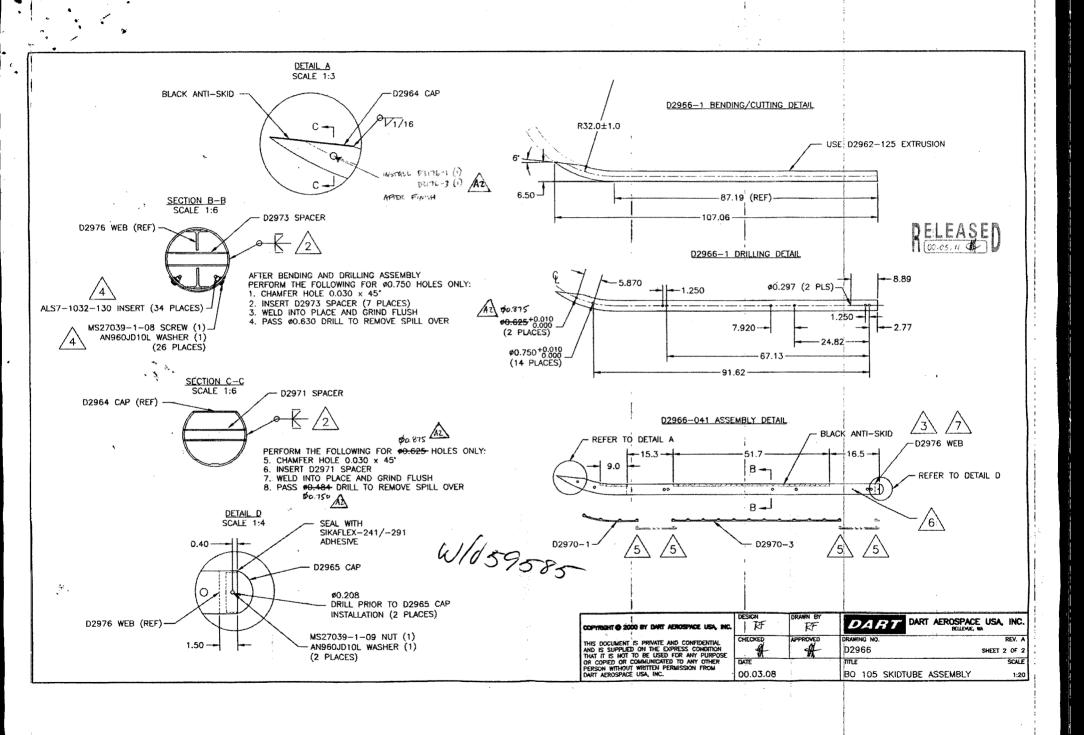
-	T	1		1	140
12	02.10.30	ADD U	3176-	1 /-3	
AI	01.01.24	CHANGE	color	TO BLACK	SAMOTEX + P

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Dart Aerosi	pace Ltd	
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W/O:		WORK ORDER CHANGES								•
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NCR:		V	WORK ORDE	R NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descript	Section B	Sign &	Verifica Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date	Jection		Office Ling	QC Inspector
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W/O:		WORK ORDER CHANGES							
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Part No):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA		_ Date: _	
	Res	solution:	Disposition	n:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)			
DATE	OTED	Description of NC Section A	Corrective Action Section		3	Varitio			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	Verification Section C	Approval Chief Eng	Approva QC Inspect
						-			

NO.192

AWS D17.1.2001 QUALIFICATION TEST RECORD

me: Barcian Elliat
number: 44849
t number: Dios wid on wa
scription: 60 105
ding Process: Tig[/ Mig[]
se materiel: Aluminium
rrent: AC[/] DC[]
TEST REQUIREMENTS AND
1EST REQUIREMENTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
UNACCEPTABLE	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier Pot Diwel	Date of Test Coupon 09-02-05
Welder Borelay Elliot	Date of Test Coupon 09 02 05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld